

Work Order ID 122204

Thursday, July 10, 2014 10:59:04 AM

122204

Page 1

Item ID: D429-793-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw

Start Date: 7/11/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/23/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: 14-7-10

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D429-793

C

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D429-793-011 CHG 002

DAS

38

9-89

14-9-29

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS

33

9-89

14-07-28

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS

38

9-89

14-9-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 122204

Thursday, July 10, 2014 10:59:04 AM

122204

Page 2

Item ID: D429-793-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw
Start Date: 7/11/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/23/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00				DAS			
130	Packaging					06		SEP 29 2014	
Packaging	Memo	0.00				9-89			
Packaging	Identify and pack for shipping as per PPP D429-793-011 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

mcj 14-09-29

mcj 14-9-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Equip/Tooling									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Picklist Print

Thursday, July 10, 2014 10:59:12 AM

Page 1

Work Order ID: 122204

122204

Parent Item: D429-793-011

D429-793-011

Parent Item Name: Bearpaw

Start Date: 7/11/14

Required Date: 7/23/14

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue 10/10/18 DL IPP Rev. B
Change AN4C12A bots to AN4C13A bolts 10/11/05 DL IPP REV:C AS PER
ECN 11-580 JLM 10-05-24 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2274		Manufactured	No			110	Each	623.0000	12	12		DAS 33 9-89	DAS 33 9-89
D2274 Radius Block									**				
	DAS 38 9-89												
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		12							
				86855		12							
				ST005		611							
				109534		6							
				110264		2							
				112466		2							
				115803		244				115803			
				117869		357							
D3456-1		Manufactured	No				Each	294.0000		8		DAS 33 9-89	DAS 33 9-89
D3456-1 Washer									**				
	DAS 38 9-89												
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		7							
				25701		7							
				ST040		287							
				107629		1							
				113126		1							
				115051		185				115051			
				121045		100							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, July 10, 2014 10:59:12 AM

Page 2

Work Order ID: 122204

122204

Parent Item: D429-793-011

D429-793-011

Parent Item Name: Bearpaw

Start Date: 7/11/14

Required Date: 7/23/14

Start Qty: 1.00

Required Qty: 1.00

D4176-1

Manufactured No

110

Each

4.0000

4 4

DAS

33

9-89

D4176-1

429 Clamp, Top

DAS

38

9-89

Location

ST451

Loc Qty

4

Loc Code

87742

4

Each

4.0000

6 6

DAS

33

9-89

D4212-1

Manufactured No

D4212-1

429 Clamp Cushion

DAS

38

9-89

Location

ST

Loc Qty

4

Loc Code

116067

4

Each

0.0000

2 2

D4353-041

Manufactured No

D4353-041

Bearpaw Assembly

DAS

38

9-89

D4354-041

Manufactured No

D4354-041

Bearpaw Wearplate Assembly

DAS

38

9-89

D4382-1

Manufactured No

D4382-1

Angled Bearpaw Clamp

DAS

38

9-89

Location

ST449

Loc Qty

1

Loc Code

80403

1

2 2

DAS

33

9-89

14-07-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, July 10, 2014 10:59:12 AM

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Work Order ID: 122204

122204

Parent Item: D429-793-011

D429-793-011

Parent Item Name: Bearpaw

Start Date: 7/11/14

Required Date: 7/23/14

Start Qty: 1.00

Required Qty: 1.00

AN4C11A

Purchased

No

Each

135.0000

8

AN4C11A

bolt

DAS

38

9-89

**

DAS
06
9-89

Location

Loc Qty

Loc Code

ST354

50

m128324

50

ST356

85

m128634

85

Each

58.0000

8

AN4C16A

Purchased

No

AN4C16A

BOLT

DAS

38

9-89

**

DAS
06
9-89

Location

Loc Qty

Loc Code

ST357

18

m128179

18

ST517a

40

122800

20

m126474

20

Each

41.0000

4

AN4C22A

DAS Purchased

No

AN4C22A

BOLT

38

9-89

**

DAS
06
9-89

Location

Loc Qty

Loc Code

ST358

10

117423

10

ST517a

31

122800

16

122843

15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 122204

Parent Item: D429-793-011

Parent Item Name: Bearpaw

122204

D429-793-011

Start Date: 7/11/14

Required Date: 7/23/14

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

Each

3,498.000

20

DAS
33
9-89

MS21043-4

Nut

DAS
38
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

ST306

3458

m128300

397

m128429

61

m128798

1500

m128818

1500

10428300

10428818

NAS1149D0463J

Purchased

No

Each

7,485.000

12

DAS
33
9-89

NAS1149D0463.J

WASHER

DAS
38
9-89

Location

Loc Qty

Loc Code

ST277

7485

121912

12

16941

8

M126221

20

M127813

22

M127904

822

M128591

101

M128995

1500

M129390

5000

127904

DAS
06
9-89

Thursday, July 10, 2014 10:59:13 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____



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5.0 PARTS LIST

QTY -011	Part Number	Description
X	D429-793-011	ULTRAPAW™ INSTALLATION
12	ID2274	RADIUS BLOCK
8	ID3456	WASHER
4	ID4176	CLAMP, TOP
6	ID4212	CLAMP CUSHION
2	ID4353-041	ULTRAPAW™ ASSY
2	ID4354-041	WEARPLATE ASSY
2	D4382	ANGLED CLAMP
8	AN4C11A	BOLT
8	AN4C16A	BOLT
4	AN4C22A	BOLT
20	MS21043	NUT
12	INAS1149D0463U	WASHERS